

22

Date: Wednesday, 5/16/2007 1:42:41 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GASKET  
 Job Number : 32414  
 Estimate Number : 12714  
 P.O. Number : N/A Part Number : D353639  
 This Issue : 5/16/2007 S.O. No. : N/A Drawing Number : D3536 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A  
 Previous Run : 30756 Material : N/A  
 Due Date : 5/31/2007 Qty: 12 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 07-02-14 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MNEO60S063 NEOPRENE SHEET 0.063



Comment: Qty.: 0.7911 sf(s)/Unit Total : 9.4928 sf(s)

NEOPRENE SHEET 0.063

Batch: B# M103104

SAD 07/05/28

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

SAD 07/05/28

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/28

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/05/29

(14)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 07/05/29 (14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:42:41 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 32414

Part Number: D353639

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

207/05/29

Job Completion



LL 07-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	32414
<b>Description:</b> Gasket		<b>Part Number:</b>	D3536-39
<b>Inspection Dwg:</b> D3536 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/-0.030	35.710	✓		M-T	
32.78	+/-0.030	32.78	✓		M-T	
29.28	+/-0.030	29.27	✓		M-T	
25.78	+/-0.030	25.78	✓		M-T	
23.25	+/-0.030	23.25	✓		M-T	
19.75	+/-0.030	19.75	✓		M-T	
17.75	+/-0.030	17.75	✓		M-T	
14.25	+/-0.030	14.25	✓		M-T	
9.50	+/-0.030	9.50	✓		Vern	
4.75	+/-0.030	4.751	✓		Vern	
5.00	+/-0.030	5.00	✓		Vern	
9.00	+/-0.030	9.00	✓		Vern	
0.30	+/-0.030	0.31	✓		Vern	
0.30	+/-0.030	0.31	✓		Vern	
1.88	+/-0.030	1.900	✓		Vern	
Ø0.19	+0.005/-0.001	Ø0.200	✓		Vern	
0.063	+/-0.010	0.061	✓		Vern	

<b>Measured by:</b>	SAD	<b>Audited by:</b>	[Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/05/28	<b>Date:</b>	Aug-29	<b>Date:</b>	N/A

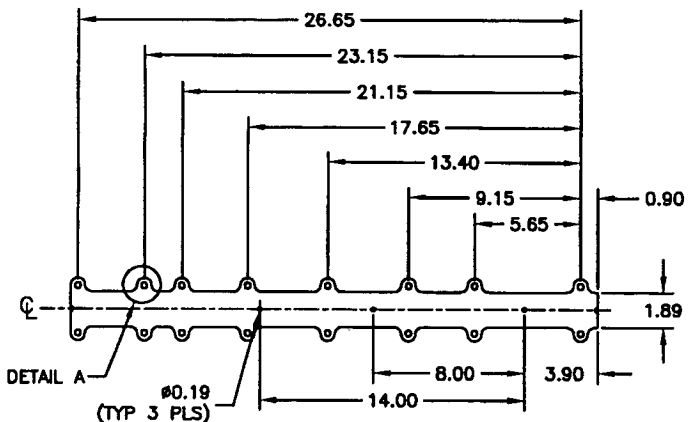
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	[Signature]

**DART**

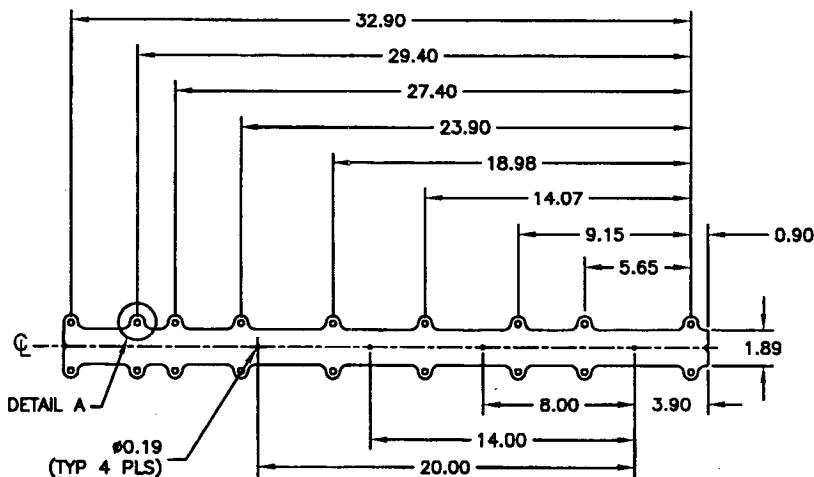
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09.02.12-1

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	AT	APPROVED		PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE



**D3536-11 GASKET**



**D3536-13 GASKET**

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 32414

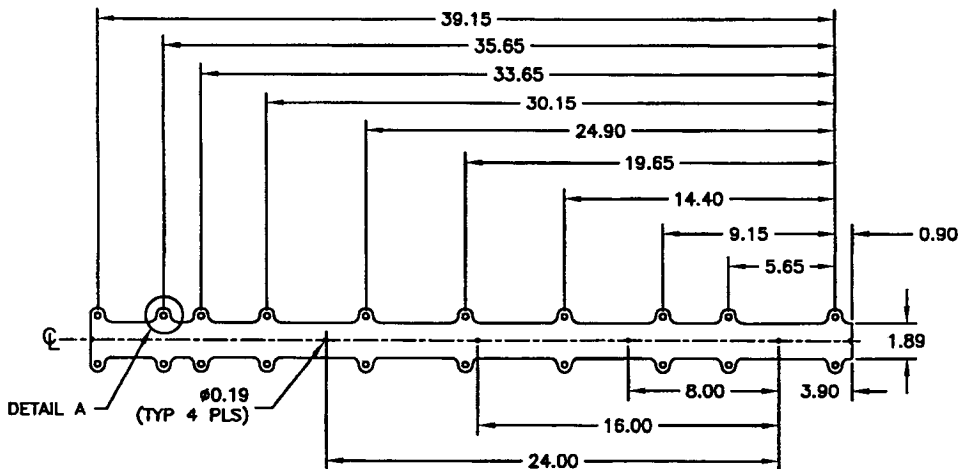
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C-C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

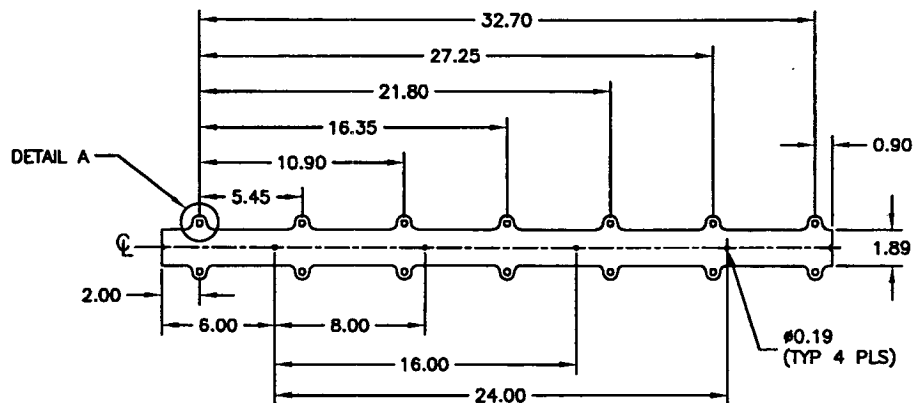
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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	REV. A SHEET 2 OF 6
	SCALE <b>1:10</b>	

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**D3536-15 GASKET**



**D3536-21 GASKET**

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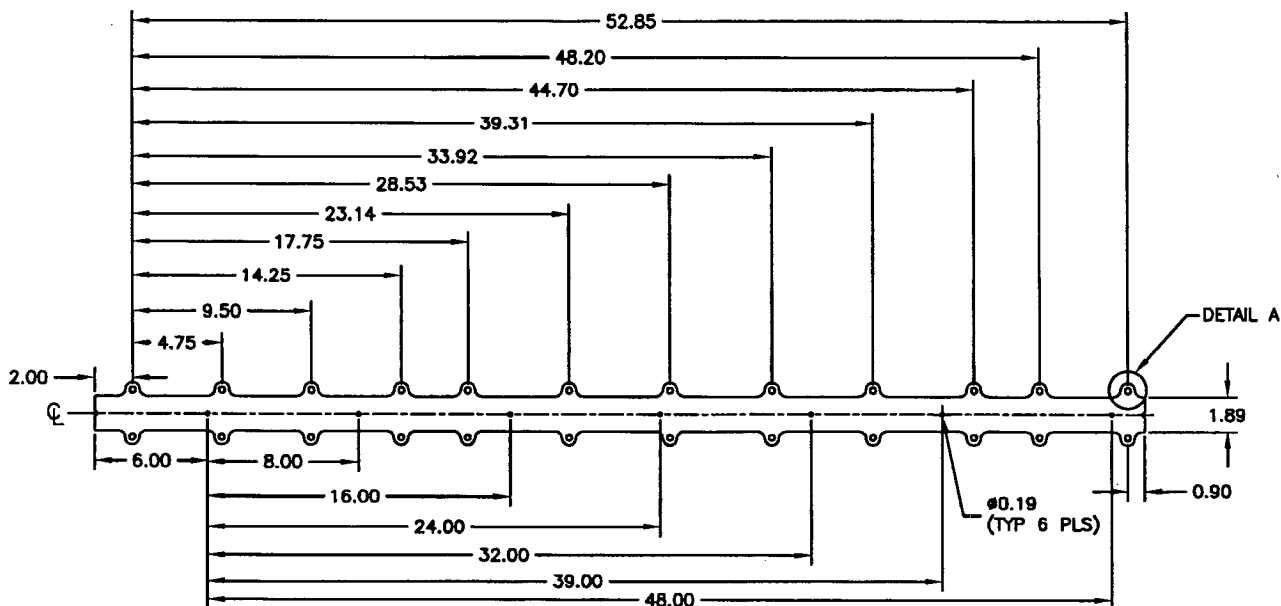
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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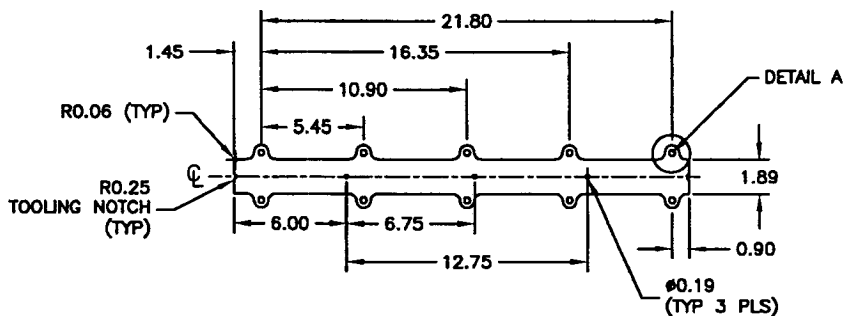
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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	REV. A SHEET 3 OF 6
	SCALE <b>1:10</b>	

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**D3536-23 GASKET**



**D3536-25 GASKET**

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NO. 32414

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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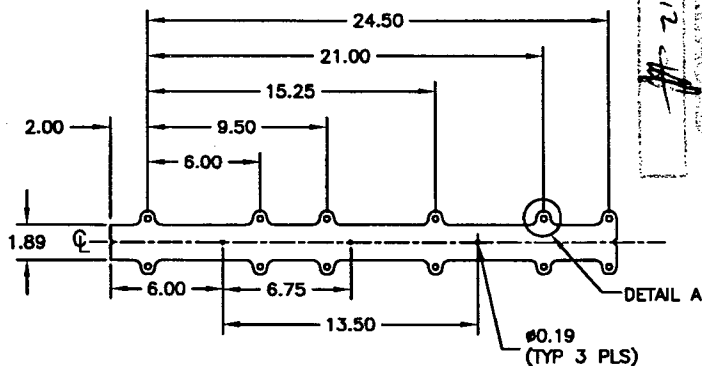


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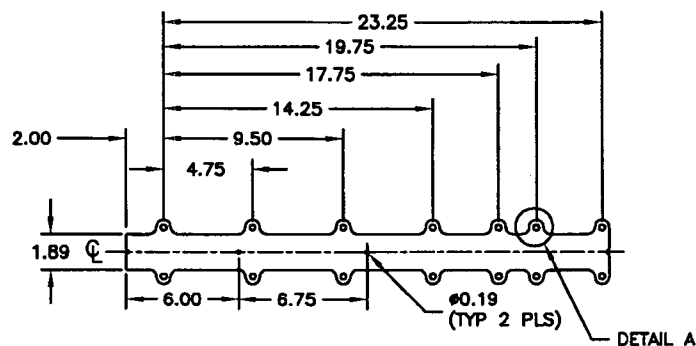
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 6
		SCALE	1:10	

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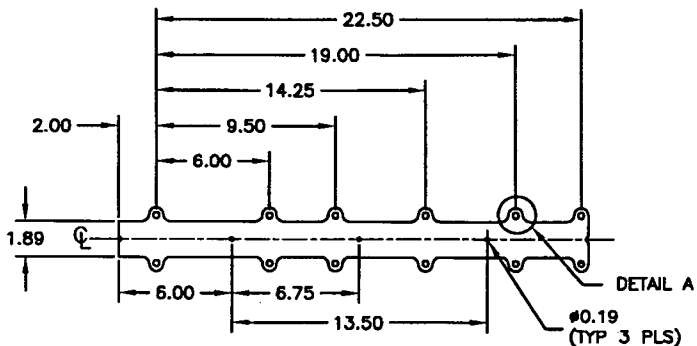
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**D3536-33 GASKET**



**D3536-35 GASKET**



**D3536-31 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

SEE PAGE 6 FOR DETAILS AND SECTION

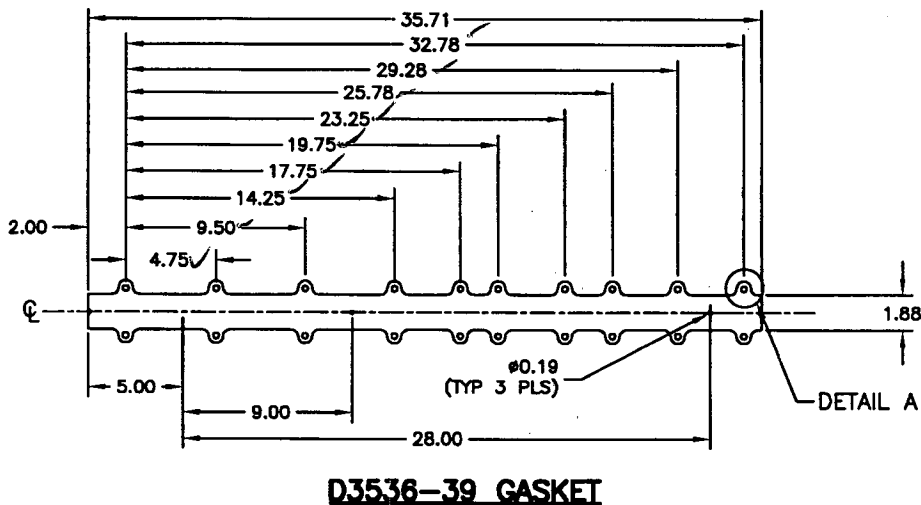
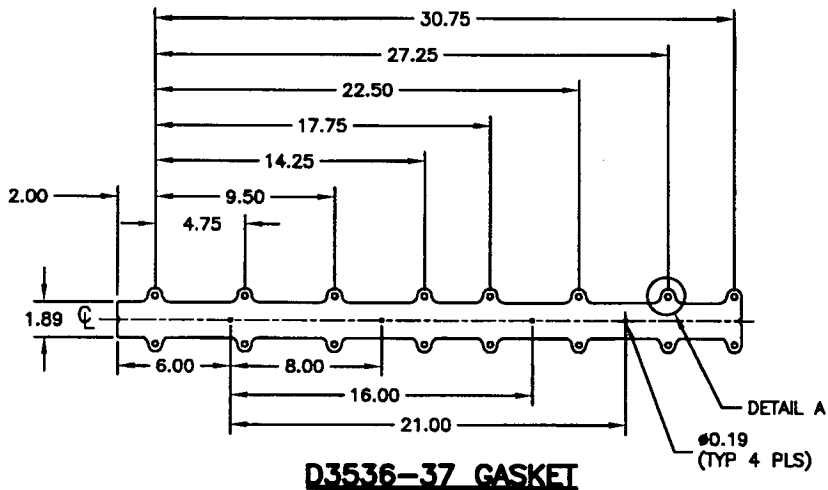
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**DART**

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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	REV. A
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 5 OF 6	SCALE <b>1:10</b>

07.02.12  
07.02.12  
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**NOTES**

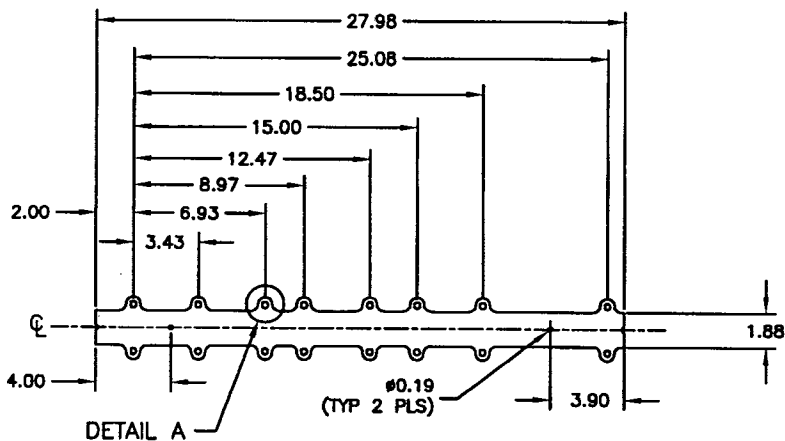
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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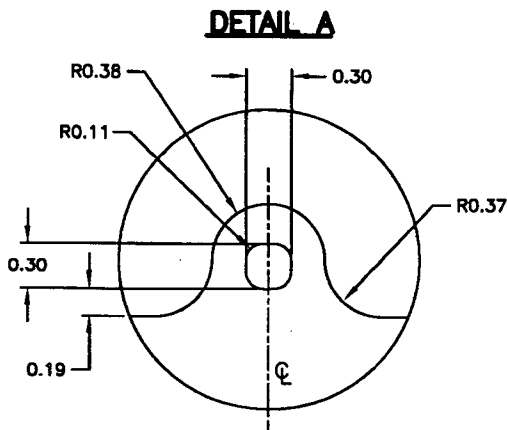


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CHECKED <b>PH</b>	APPROVED <b>PH</b>	DRAWING NO. <b>D3536</b>	REV. A
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 6 OF 6	SCALE <b>1:10</b>

REWORKED  
07.01.12 **CH**



**D3536-41 GASKET**



**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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